

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
1 April 2004 (01.04.2004)

PCT

(10) International Publication Number
WO 2004/026017 A3

(51) International Patent Classification⁷: B21C 37/30

[US/US]; 19115 Prospect Ridge Lane, Houston, TX 77094 (US). RING, Lev [US/US]; 14126 Heatherhill Place, Houston, TX 77077 (US).

(21) International Application Number:
PCT/US2003/025742

(74) Agents: MATTINGLY, Todd et al.; Haynes and Boone, LLP, 1000 Louisiana Street, Suite 4300, Houston, TX 77002-5012 (US).

(22) International Filing Date: 18 August 2003 (18.08.2003)

(25) Filing Language: English

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(26) Publication Language: English

(30) Priority Data:
60/412,177 20 September 2002 (20.09.2002) US

(84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE,

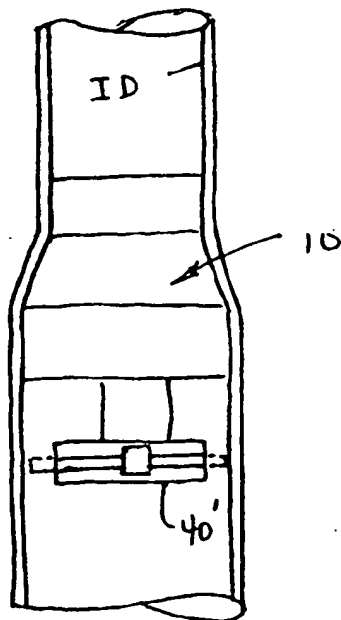
(71) Applicant (*for all designated States except US*): ENVENTURE GLOBAL TECHNOLOGY [US/US]; 16200 A Park Row, Houston, TX 77084 (US).

(72) Inventors; and

(75) Inventors/Applicants (*for US only*): SHUSTER, Mark

[Continued on next page]

(54) Title: RESIDUAL STRESSES IN EXPANDABLE TUBULAR CASING



(57) Abstract: An elongated section of steel tubing (30) has an outer circumferential surface and an inner circumferential surface defining an elongated axial passage through the tubing. An expansion mandrel (10) is moved through the tubing for radially expanding the tubing. An impact member (40) is provided for travel through the length of the axial passage. A plurality of movable impactors (42) are mounted to extend from the impact member. The impactors are driven for repeated contact with the inner circumferential surface as the impact member is moved through the tubing subsequent to the expansion mandrel for contacting the expanded inner circumferential surface along the entire length of the axial passage. Movement of the impactors is ultrasonic.

WO 2004/026017 A3



ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO,
SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM,
GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

— *before the expiration of the time limit for amending the
claims and to be republished in the event of receipt of
amendments*

Declaration under Rule 4.17:

— *of inventorship (Rule 4.17(iv)) for US only*

(88) Date of publication of the international search report:

15 July 2004

Published:

— *with international search report*

*For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.*

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US03/25742

A. CLASSIFICATION OF SUBJECT MATTER

IPC(7) : B21C 37/30

US CL : 72/370.06

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 72/370.06, 370.08, 53, 75

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2,929,741 A (STROCK et al.) 05 January 1960, (05-01-1960), whole doc.	23
Y		15-19
X	US 4,491,001 A (YOSHIDA et al.) 01 January 1985 (01-01-1985), whole doc.	1-3, 5-7, 21, 22
Y		4, 8, 15-19
Y	US 6,343,495 B1 (CHEPPE et al.) 05 February 2002 (05-02-2002), whole doc.	4, 8

☐ Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T"

later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X"

document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y"

document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&"

document member of the same patent family

Date of the actual completion of the international search

03 May 2004 (03.05.2004)

Date of mailing of the international search report

27 MAY 2004

Name and mailing address of the ISA/US

Mail Stop PCT, Attn: ISA/US
Commissioner for Patents
P.O. Box 1450
Alexandria, Virginia 22313-1450

Facsimile No. (703) 305-3230

Authorized officer

Lowell A Larson

Telephone No. 703 308-1148

Shelly H. Venev
Paralegal Specialist
Tech. Center 3700

WO 2004/026073 A2



Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE,
ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO,
SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM,
GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Declaration under Rule 4.17:

— of inventorship (Rule 4.17(iv)) for US only

Published:

— without international search report and to be republished
upon receipt of that report

*For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.*

ROTATING MANDREL FOR EXPANDABLE TUBULAR CASING**Cross Reference To Related Applications**

[001] The present application claims the benefit of the filing dates of (1) U.S. provisional patent application serial no. 60/412,187, attorney docket no 25791.128, filed on 9/20/2002, the disclosure of which is incorporated herein by reference.

[002] The present application is related to the following: (1) U.S. patent application serial no. 09/454,139, attorney docket no. 25791.03.02, filed on 12/3/1999, (2) U.S. patent application serial no. 09/510,913, attorney docket no. 25791.7.02, filed on 2/23/2000, (3) U.S. patent application serial no. 09/502,350, attorney docket no. 25791.8.02, filed on 2/10/2000, (4) U.S. patent no. 6,328,113, (5) U.S. patent application serial no. 09/523,460, attorney docket no. 25791.11.02, filed on 3/10/2000, (6) U.S. patent application serial no. 09/512,895, attorney docket no. 25791.12.02, filed on 2/24/2000, (7) U.S. patent application serial no. 09/511,941, attorney docket no. 25791.16.02, filed on 2/24/2000, (8) U.S. patent application serial no. 09/588,946, attorney docket no. 25791.17.02, filed on 6/7/2000, (9) U.S. patent application serial no. 09/559,122, attorney docket no. 25791.23.02, filed on 4/26/2000, (10) PCT patent application serial no. PCT/US00/18635, attorney docket no. 25791.25.02, filed on 7/9/2000, (11) U.S. provisional patent application serial no. 60/162,671, attorney docket no. 25791.27, filed on 11/1/1999, (12) U.S. provisional patent application serial no. 60/154,047, attorney docket no. 25791.29, filed on 9/16/1999, (13) U.S. provisional patent application serial no. 60/159,082, attorney docket no. 25791.34, filed on 10/12/1999, (14) U.S. provisional patent application serial no. 60/159,039, attorney docket no. 25791.36, filed on 10/12/1999, (15) U.S. provisional patent application serial no. 60/159,033, attorney docket no. 25791.37, filed on 10/12/1999, (16) U.S. provisional patent application serial no. 60/212,359, attorney docket no. 25791.38, filed on 6/19/2000, (17) U.S. provisional patent application serial no. 60/165,228, attorney docket no. 25791.39, filed on 11/12/1999, (18) U.S. provisional patent application serial no. 60/221,443, attorney docket no. 25791.45, filed on 7/28/2000, (19) U.S. provisional patent application serial no. 60/221,645, attorney docket no. 25791.46, filed on 7/28/2000, (20) U.S. provisional patent application serial no. 60/233,638, attorney docket no. 25791.47, filed on 9/18/2000, (21) U.S. provisional patent application serial no. 60/237,334, attorney docket no. 25791.48, filed on 10/2/2000, (22) U.S. provisional patent application serial no. 60/270,007, attorney docket no. 25791.50, filed on 2/20/2001, (23) U.S. provisional patent application serial no. 60/262,434, attorney docket no. 25791.51, filed on 1/17/2001, (24) U.S. provisional patent application serial no. 60/259,486, attorney docket no. 25791.52, filed on 1/3/2001, (25) U.S. provisional patent application serial no. 60/303,740, attorney docket no. 25791.61, filed on 7/6/2001, (26) U.S. provisional patent application serial no. 60/313,453, attorney docket no. 25791.59, filed on 8/20/2001, (27) U.S. provisional patent application serial no. 60/317,985, attorney docket no. 25791.67, filed on 9/6/2001, (28) U.S. provisional patent application serial no. 60/3318,386, attorney docket no. 25791.67.02, filed on 9/10/2001, (29) U.S. utility patent application serial no. 09/969,922, attorney docket no. 25791.69, filed on 10/3/2001, (30) U.S. utility patent

application serial no. 10/016,467, attorney docket no. 25791.70, filed on 12/10/2001, (31) U.S. provisional patent application serial no. 60/343,674, attorney docket no. 25791.68, filed on 12/27/2001, (32) U.S. provisional patent application serial no. 60/346,309, attorney docket no. 25791.92, filed on 1/7/2002, (33) U.S. provisional patent application serial no. 60/372,048, attorney docket no. 25791.93, filed on 4/12/2002, (34) U.S. provisional patent application serial no. 60/380,147, attorney docket no. 25791.104, filed on 5/6/2002, (35) U.S. provisional patent application serial no. 60/387,486, attorney docket no. 25791.107, filed on 6/10/2002, (36) U.S. provisional patent application serial no. 60/387,961, attorney docket no. 25791.108, filed on 6/12/2002, (37) U.S. provisional patent application serial no. 60/394,703, attorney docket no. 25791.90, filed on 6/26/2002, (38) U.S. provisional patent application serial no. 60/397,284, attorney docket no. 25791.106, filed on 7/19/2002, (39) U.S. provisional patent application serial no. 60/398,061, attorney docket no. 25791.110, filed on 7/24/2002, (40) U.S. provisional patent application serial no. 60/405,610, attorney docket no. 25791.119, filed on 8/23/2002, (41) U.S. provisional patent application serial no. 60/405,394, attorney docket no. 25791.120, filed on 8/23/2002, (43) U.S. provisional patent application serial no. 60412,653, attorney docket no. 25791.118, filed on 9/20/2002, (44) U.S. provisional patent application serial no. 60/412,544, attorney docket no. 25791.121, filed on 9/20/2002, (45) U.S. provisional patent application serial no. 60/412,196, attorney docket no. 25791.127, filed on 9/20/2002, and (46) U.S. provisional patent application serial no. 60/412,371, attorney docket no. 25791.129, filed on 9/20/2002, the disclosures of which are incorporated herein by reference.

Background of the Invention

[003] The present invention relates generally to tubular steel well casing and more particularly to an expansion mandrel which reduces stress during expansion of the casing.

[004] Solid tubular casing of substantial length is used as a borehole liner in downhole drilling. The casing is comprised of end-to-end interconnected segments of steel tubing to protect against possible collapse of the borehole and to optimize well flow. The tubing often reaches substantial depths and endures substantial pressures.

[005] It is present practice to expand the steel tubing downhole by using a mandrel. This is a cold-working process which presents substantial mechanical challenges. This technology is known as solid expandable tubular (SET) technology. This cold-working process deforms the steel without any additional heat beyond what is present in the downhole environment.

[006] An expansion cone, or mandrel, is used to permanently mechanically deform the pipe. The cone is moved through the tubing by a differential hydraulic pressure across the cone itself, and/or by a direct mechanical pull or push force. The differential pressure is pumped through an inner-string connected to the cone, and the mechanical force is applied by either raising or lowering the inner string.

[007] Progress of the cone through the tubing deforms the steel beyond its elastic limit into the plastic region, while keeping stresses below ultimate yield. Expansions greater than 20%, based on pipe ID, have been accomplished. However, most applications using 4 1/4 - 13 3/8 inch tubing have required expansions less than 20%.

[008] At the bottom of the SET system is a canister, known as the "launcher," that contains the expansion cone. The launcher is constructed of thin-wall, high-strength steel that has a thinner wall thickness than the expandable casing. Because the launcher has a thinner wall and its OD is the same as the drift of the previous casing string, it can be tripped into the hole through the previous casing string.

[009] The difference in wall thickness of the launcher and the elastomer-coated hanger joint(s) allows the expanding pipe to be sealed, or "clad," to the previous casing string. The expanded pipe ends up with an OD that is greater than the OD of the launcher, due to its greater wall thickness. The ID of the pipe expands to the same ID of the launcher, which is a function of expansion cone OD.

[0010] Contact between cylindrical mandrel and pipe ID during expansion leads to significant forces due to friction. It would be beneficial to provide a mandrel which could reduce friction during the expansion process.

Summary Of The Invention

[0011] One embodiment accordingly, provides an apparatus and method for reducing such friction. To this end, the apparatus includes an expansion mandrel having a longitudinal axis, a first end, a second end and a tapered portion between the first and second ends. A plurality of expansion segments are provided on the expansion portion. Each segment is angularly disposed relative to the longitudinal axis.

[0012] A principle advantage of this embodiment is that the angularly disposed segments reduce contact with the ID of the casing. The angular relationship of the segments cause the mandrel to move in a helical path within the casing ID thereby establishing a self-feeding characteristic in the mandrel.

Brief Description of the Drawings

[0013] Fig. 1 is a side view illustrating an embodiment of an expansion mandrel.

[0014] Fig. 2A is a partial side view illustrating an embodiment of a rotatable segment.

[0015] Figs. 2 – 5 are partial side views illustrating embodiments of expansion segment profiles.

[0016] Fig. 6 is a partial side view illustrating an embodiment of an expansion segment including friction lowering buttons.

[0017] Figs. 7A – C are side views illustrating an embodiment of an expansion mandrel and a resulting expanded casing.

Detailed Description of the Illustrative Embodiments

[0018] An expansion mandrel is generally designated 10 in Fig. 1, and includes a main body 12 having a longitudinal axis L which extends between a first end 14 and a second end 16 of the main

body 12. An external surface 18 of body 12 has a first diameter D1 at first end 14, and a second diameter D2, larger than D1, at second end 16, interconnected by a tapered expansion portion E. The first end 14 of body 12 is a leading end being of the smaller diameter D1, and the second end 16 is a trailing end being of the larger diameter D2.

[0019] A plurality of expansion segments 20 are provided on the expansion portion E. Each segment 20 is elongated and has an axis angularly disposed at an angle (a) from about 1° to about 3° with the axis L. A segment 20, Fig. 2A, may be an elongated, substantially oval shaped segment, inserted and rotatably seated in a pocket 19 formed in surface 18 of mandrel 10. In this manner, the segment 20 rotates in a direction D about its longitudinal axis L' independent of the mandrel 10 which moves in a spiral path through a steel casing 30, discussed below. Each segment may be machined onto surface 18, Fig. 2, so as to protrude therefrom. Also, each segment can be an insert, Fig. 3, having a first portion 20a imbedded in surface 18 and a second portion 20b protruding from surface 18. Each segment 20 has a leading end 22 disposed toward end 14, a trailing end 24 disposed toward end 16, and an intermediate portion 26 between ends 22 and 24. As illustrated in Figs. 2 and 3, ends 22 and 24 may be flush with surface 18, whereas intermediate portion 26 protrudes from surface 18.

Alternatively, end 22 may be flush with surface 18, Fig. 4, and end 24, along with intermediate portion 26 may protrude from surface 18. In another embodiment, Fig. 5, both ends 22, 24 and intermediate portion 26 may protrude from surface 18. In a further embodiment, Fig. 6, a plurality of friction lowering buttons 28 may protrude from each segment 20. Buttons 28 may be machined onto or embedded in segment 20 and may be formed of a metal or diamond material.

[0020] Mandrel 10, Figs. 7A, 7B and 7C, includes segments 20, and is used for expanding an elongated section of steel casing 30 defining an elongated passage 32 therein. Mandrel 10 is positioned, for example in a position A, Fig. 7A, and is axially moved through the passage 32 to an exemplary position B, Fig. 7B, and position C, Fig. 7C, to expand passage 32 from an original diameter O to an expanded final diameter F. Due to the angular disposition of segments 20, Fig. 1, mandrel 10 rotates during movement in a helix as indicated by a direction of rotation at arrow R, Fig. 7C.

[0021] It should be understood that the angle (a) may be varied as well as the geometry and material of each segment 20. Also, each segment 20 may extend over the entire length of the mandrel 10 or only over a portion thereof. In any case, friction forces are greatly reduced by the reduced surface area of contact between the mandrel 10 and the casing 30.

[0022] Although illustrative embodiments have been shown and described, a wide range of modification, change and substitution is contemplated in the foregoing disclosure and in some instances, some features of the embodiments may be employed without a corresponding use of other features. Accordingly, it is appropriate that the appended claims be construed broadly and in a manner consistent with the scope of the embodiments disclosed herein.

Claims

1. An apparatus for expanding tubular casing comprising:
 - an expansion mandrel having a longitudinal axis, a first end, a second end and a tapered expansion portion between the first and second ends; and
 - a plurality of expansion segments, on the expansion portion, each segment being angularly disposed relative to the longitudinal axis.
2. The apparatus as defined in claim 1 wherein the angular disposition of each segment is from about 1° to about 3°.
3. The apparatus as defined in claim 1 wherein each segment is machined to protrude from an external surface of the mandrel.
4. The apparatus as defined in claim 1 wherein each segment has a first portion seated in an external surface of the mandrel and a second portion protruding from the external surface.
5. The apparatus as defined in claim 4 wherein each segment is rotatably seated in a pocket formed in the external surface.
6. The apparatus as defined in claim 1 wherein each segment has a leading end disposed toward the first end of the mandrel and a trailing end disposed toward the second end of the mandrel.
7. The apparatus as defined in claim 6 wherein the leading end is flush with an external surface of the mandrel and the trailing end is flush with the external surface of the mandrel, and wherein an intermediate portion between the leading and trailing ends protrudes from the external surface.
8. The apparatus as defined in claim 6 wherein the leading end is flush with an external surface of the mandrel and the trailing end protrudes from the external surface.
9. The apparatus as defined in claim 6 wherein the leading and trailing ends protrude from an external surface of the mandrel.
10. The apparatus as defined in claim 1 wherein each segment includes a plurality of friction lowering buttons extending therefrom.
11. The apparatus as defined in claim 10 wherein the friction lowering buttons are formed of a diamond material.
12. The apparatus as defined in claim 10 wherein the friction lowering buttons are formed of a metallic material.
13. A method for expanding tubular casing comprising:
 - providing an elongated section of steel casing having a longitudinal axis, an outer circumferential surface and an inner circumferential surface defining an elongated axial passage through the tubing;

positioning an expansion mandrel for movement through the passage for radially expanding the tubing, the expansion mandrel having a first end, a second end and a tapered expansion portion between the first and second ends;

providing a plurality of expansion segments on the expansion portion, each segment being angularly disposed relative to the longitudinal axis; and

moving the mandrel through the axial passage whereby the segments rotate the mandrel during expansion of the casing.

14. The method as defined in claim 13 further comprising:
orienting each segment at an angle of from about 1° to about 3°.
15. The method as defined in claim 13 further comprising:
forming each segment to protrude from an external surface of the mandrel.
16. The method as defined in claim 15 further comprising:
rotatably seating each segment in a respective pocket formed in the external surface.
17. The method as defined in claim 13 further comprising:
providing each segment with a leading end disposed toward the first end of the mandrel and a trailing end disposed toward the second end of the mandrel.
18. The method as defined in claim 17 further comprising:
forming the leading end flush with an external surface of the mandrel and forming the trailing end to protrude from the external surface.
19. The method as defined in claim 17 further comprising:
forming the leading and trailing ends flush with an external surface of the mandrel and forming an intermediate portion of each segment to protrude from the external surface.
20. The method as defined in claim 17 further comprising:
forming the leading and trailing ends to protrude from an external surface of the mandrel.
21. The method as defined in claim 17 further comprising:
providing each segment to include a plurality of low friction buttons extending therefrom.
22. A method for expanding tubular casing comprising:
providing an elongated section of steel casing having a longitudinal axis, an outer circumferential surface and an inner circumferential surface defining an elongated axial passage through the tubing;
positioning an expansion mandrel for movement through the passage for radially expanding the tubing, the expansion mandrel having a first end, a second end and a tapered expansion portion between the first and second ends;

providing a means on the mandrel for reducing friction and for causing the mandrel to rotate in response to the mandrel being moved along the inner circumferential surface of the casing; and

moving the mandrel through the axial passage for expanding the casing.

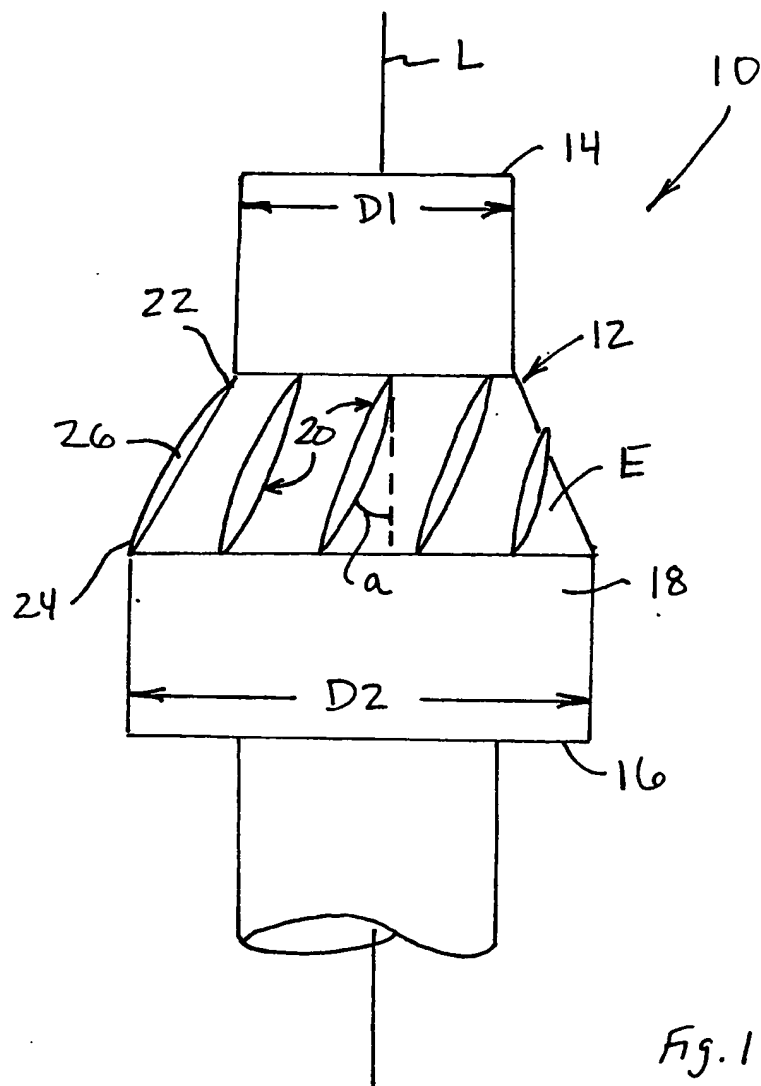


Fig. 1

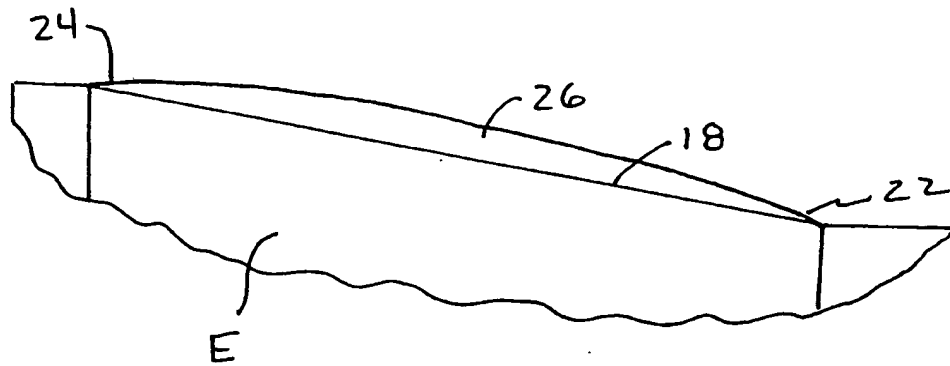


Fig. 2

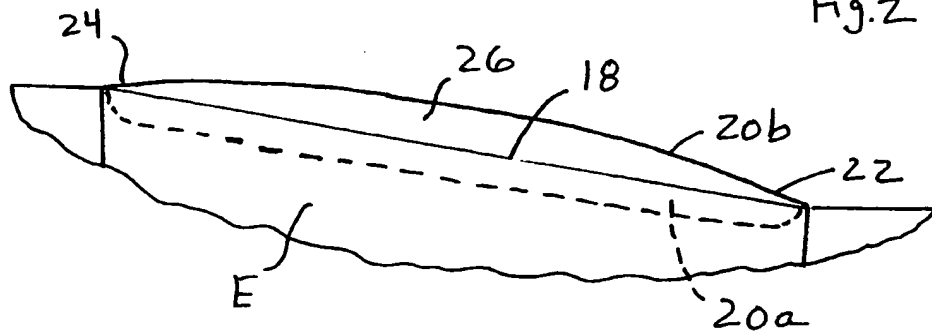


Fig. 3

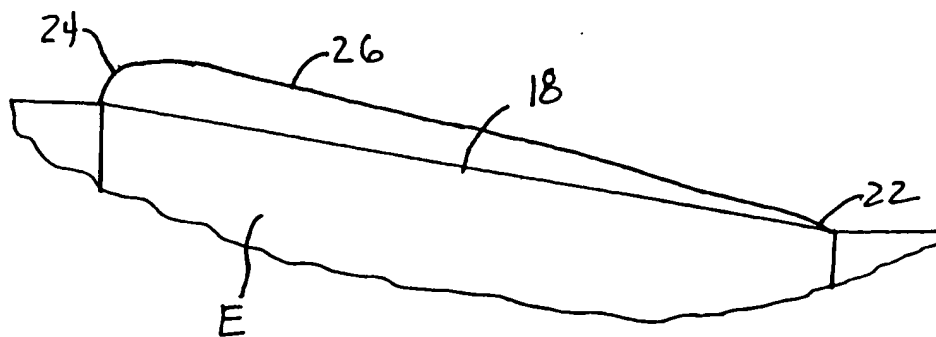


Fig. 4

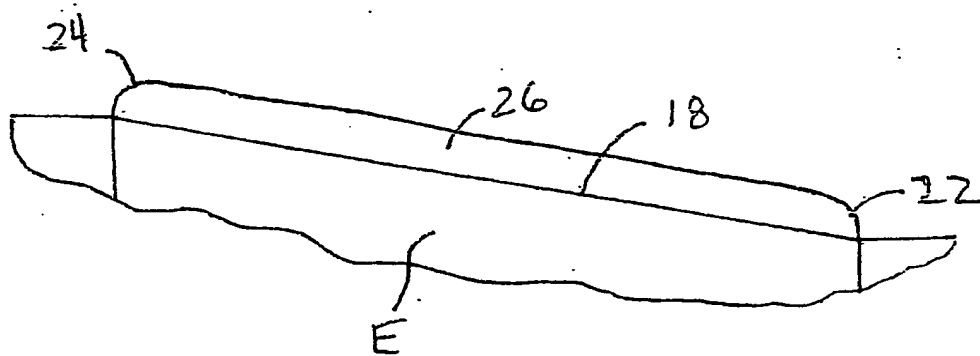


Fig. 5

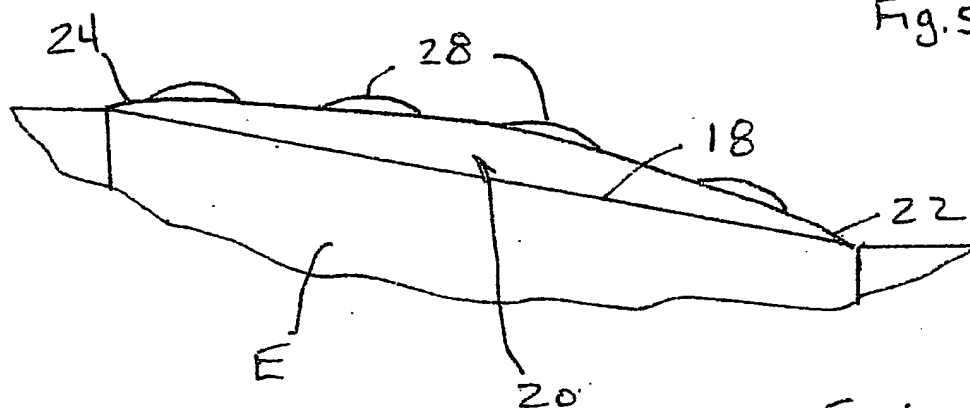


Fig. 6

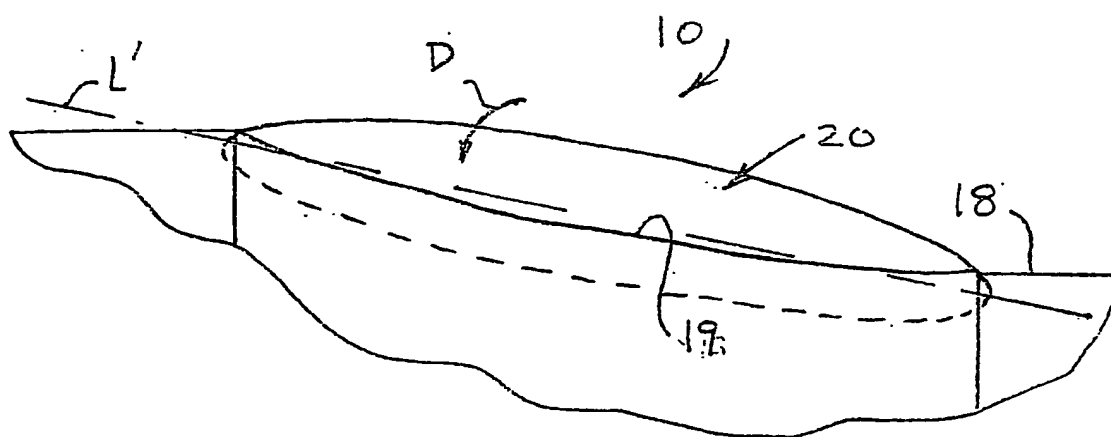


Fig. 2A

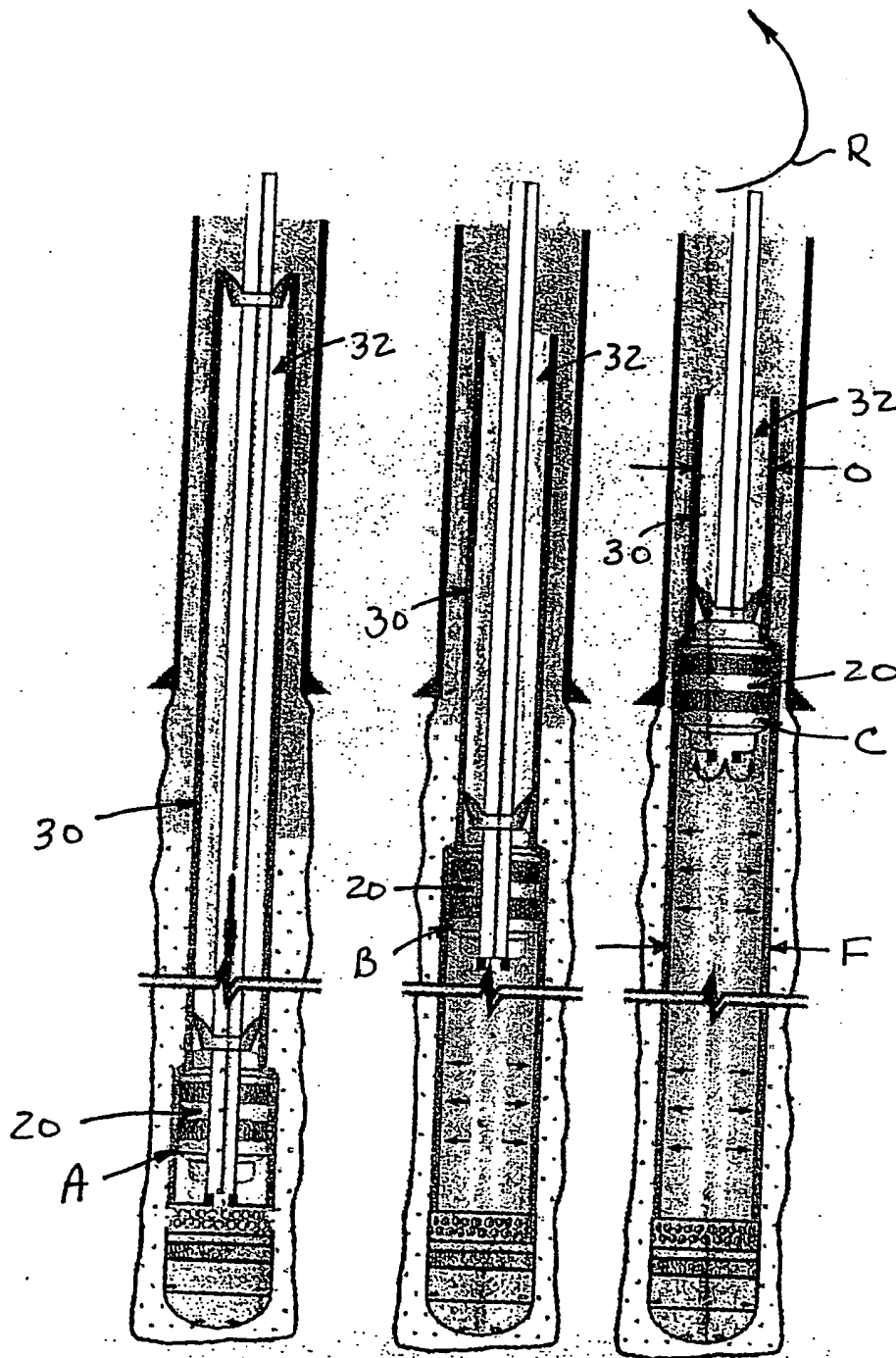


Fig. 7A

Fig. 7B

Fig. 7C